er ID 122266 4, 2014 1:54:29 PM		*122					Page 1			
D3544-041 Clamp		Accept	*N900	040	10	N* 5				S1*
7/14/14 Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:					"IU,	5 /"
Process Plan:MUS	Date: 14-07-15	Tooling:	Date:Date:			R			*N	R1*
QC:	Date:	SPC (Y/N):					S	Stop	*\	R2*
Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Reject	Insp. Stamp
Revision Nbr						·				<u> </u>
Rev A										
Small Fab		0.00				20x			SEP 2	4 2014
	s per Dwg D3544									
QC5- Inspect part compl	eteness to step on W/O	0.00								Dan
Memo		0.00				20_	Ø		14/09/2	9 38 9 89
Identify as per dwg & St	ock Location: <u>S+5</u> 42					20		/.	No	14/09
	D3544-041 Clamp 7/14/14 Start Qty: 20.00 7/14/14 Req'd Qty: 20.00 Process Plan: MCS QC: Operation Description Revision Nbr Rev A Small Fab Memo Assemble as QC5- Inspect part complement	D3544-041 Clamp 7/14/14 Start Qty: 20.00 *20* 7/14/14 Req'd Qty: 20.00 *20* Process Plan:	D3544-041 Accept	D3544-041	D3544-041	D3544-041	D3544-041	D3544-041	D3544-041	D3544-041

Packaging

DQA:			Date:														
						WORK ORDER NON-CONFORMANCE / UPDATE											
QA Closed:			Date:							W	ork Order up	date only					
Work Order:						DISPOSITION				AGAINST DEPARTMENT/PROCESS							
work Order:						Rework		Skid-tube	Crosstube	7	Water Jet	Engine	eering				
Part No.						Scrap			Machining	Small Fab		d. Eng. Coor. re/Packaging		Quality Other			
NCR No.					Use-as-is Suspected Unapproved					, Recystor	Supplier	<u></u>					
Root					Desc	ption of work order update Initia			Actio	on	Sign &			·			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date Verification		QCI	nspector			
Design																	
Doc/Data																	
Equip/Tooling																	
Handling/Pre																	
Material																	
Operator																	
Offset/Setup	ı	<u> </u>					ŀ										
Process																	
Supplier			,														
Training		i	1														
Transport					<u>.</u>												
Unapproved												<u> </u>					
							FA	ULT CA	TEGORY								
Landi	ng (Gear				General	_	1		_	-		¬_				
		Bending			_	Bend		1	Program	<u> </u>	Outside Dim		Pressure	e/Forced			
		Centre No	ot Concer	ntric		BOM/Route	<u> </u>	Grain		-	Over/Under		Set-up				
	Cracks					Broken/Damage/Defect	<u> </u>	Hardwa		_	Part Incorre	⊢		ature/Cure			
	Crimp/Kink/Ripple/Wave					Burrs	_	4 '	ion incomplete/Und	·	Part Lost/Mi	issing	Weld				
	Cuffs					Contamination		4	tions Incomplete/U	nclear	Part Moved	L	Wrong S	Stock Pulled			
Crushing					Countersink	_	4	gned/off center	<u> </u>	Positioned V		¬					
Heat Treat					Cut Too Short	\vdash	Mislab		L	Power Loss/	Surge	Other					
Inspection Strip in Tube					Drawing	_	Misrea						······································				
		Marks/Ch	natter		L	Drill Holes		Off-set									
		Turning S			L	Finish		4	Calibration		_			 			
	Wave/Twist in Tube					Fit/Function		Out of	Sequence								

Work Ord Monday, July 1-							Page 2					
Item ID: Revision ID: Item Name:	D3544-042	1		Accept	*N900	N *	Setup	Start Stop		S1* S2*		
Start Date: Required Date: Reference:	tart Date: 7/14/14 Start Qty: 20.00 Required Date: 7/14/14 Req'd Qty: 20.00				Cust Item ID: Customer:						!	5 /"
Approvals:	Process P	Plan:	Date:	Tooling: SPC (Y/N):	Date:				Run	Start Stop		R1* R2*
Sequence ID/ Work Center II	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Reje Qty		Reject Tumber	Insp. Stamp
1.30		Memo	or order release	0.00				MU	<u> </u>	14	09-7	0

Quality Control

Mr 930

DQA:	Date: Date: WORK ORDER NON-CONFORMANCE / UPDATE										"DART			
QA Closed:		Date:			Work Order update only									
					DISPOSITION				AGAINST I	DEP	ARTMENT	PROCESS		
Work Orde	r:				Rework Skid-tube Crosstube							Water Jet	Engineering	
Part N	lo				Scrap			Machining	Small Fab	\dashv	Prod	d. Eng. Coor.	Quality	
i dicit	···		,		Use-as-is			noforming	Finishing			e/Packaging	Other	
NCR N	lo			<u> </u>	Suspected Unapproved			Large Fab	Composite	 				
Root	Desc			Desc	ription of work order update		Initial	Ac	tion	T	Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector	
Design														
Doc/Data							ets Par							
quip/Tooling		}												
Handling/Pre														
Material														
Operator														
Offset/Setup	1													
Process			l											
Supplier														
Training														
Transport		1												
Unapproved						L								
						FA	ULT CA	regory					···	
Landi	ng Gear				General		-		,	_		·	–	
	Bending				Bend	<u></u>	Folio/F	Program			Outside Dim		Pressure/Forced	
	Centre N	ot Conce	ntric		BOM/Route		Grain			\blacksquare	Over/Under		Set-up	
	Cracks				Broken/Damage/Defect	<u>_</u>	Hardwa			\vdash	Part Incorre	⊢	Temperature/Cure	
	Crimp/Ki	nk/Ripple	e/Wave		Burrs	L	⊣ '	ion Incomplete/U	·		Part Lost/Mi	ssing	Weld	
	Cuffs				Contamination		-4	tions Incomplete/	'Unclear	—	art Moved		Wrong Stock Pulled	
	Crushing				Countersink		- '	gned/off center		-	Positioned V		, – 1	
	Heat Tre	at			Cut Too Short	_	Mislabe			∐ F	ower Loss/	Surge	Other	
	Inspection	n Strip ir	Tube		Drawing	L	Misrea			_				
	Marks/C	hatter			Drill Holes ,		Off-set			_				
	Turning S	Sequence)		Finish		Outof	Calibration		_				
	Wave/Tv	vist in Tu	be		Fit/Function		Out of	Sequence						

Work Order ID: 122266

122266

Parent Item:

D3544-041

D3544-041

Parent Item Name: Clamp

Start Date: 7/14/14

Required Date: 7/14/14

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A New Issue 06-08-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2182		Manufactured	No			100	f	390.2500	0.585	13	-		·
D2182 Heat Shrink									**			DAS 28 9-89	SEP 2 4 2014
				Location		Loc	Qty	Loc Code					
				ST511	112922		0.25 0.25	Å		15/8	}		
D2947		Manufactured	No			100	Each	25.0000	1 -	20			
D2947									**		DA	S	
·	•			Location		Loc	<u>Oty</u>	Loc Code			2: 9:1	8 89	
				ST456a			25			116826			
					102376		1						
					110101		24						

DQA:		Date:									"DART						
						WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only AEROSPA WORK ORDER NON-CONFORMANCE / UPDATE											
QA Closed:			Date:								Vork Orde	r updat	te only				
Work Orde	٠.				DISPOSITION				AGAINST DEPARTMENT/PROCESS								
WOIK OIU						Rework			Skid-tube	Crosstube	-	Water Jet Engineering					
Part N	lo.					Scrap		Machining	Small Fab		Prod. E	Quality					
	-					Use-as-is		Thern	noforming	Finishing	Rec/s	Store/F	Packaging	Other			
NCR N	lo					Suspected Unapproved	pproved Large Fab Composite Supplier						Supplier				
Root					Desc	ription of work order update		nitial	Actio	on	Sign &						
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	\	/erification	QC Inspector			
Design	ic	7. Mar															
Doc/Data		€ 9+-															
Equip/Tooling Handling/Pre	\dashv				-,												
Material	\dashv																
Operator	ᅱ																
Offset/Setup	ᆿ	.2,1	٠.				İ										
Process	\dashv																
Supplier	司	. •	, P														
Training			ļ .	-										•			
Transport																	
Unapproved											- The second second						
						<u>``</u>	FAI	ULT CA	TEGORY								
Landi	ng G	iear				General	. s. d.	•		-			-	<u>. </u>			
		Bending				Bend		Folio/F	Program	<u> </u>	Outside			Pressure/Forced			
		Centre No	ot Concer	ntric		BOM/Route		Grain		Ļ	Over/Ur			Set-up			
	Cracks					Broken/Damage/Defect		Hardwa		<u> </u>	Part Inco			Temperature/Cure			
	Crimp/Kink/Ripple/Wave					Burrs		4 '	ion Incomplete/Un		Part Los		ng L	Weld			
,	Cuffs					Contamination	_	-	tions Incomplete/U	Inclear	Part Mo			Wrong Stock Pulled			
	Crushing				L	Countersink		-1	gned/off center		Position			—] _{au}			
Heat Treat					Cut Too Short		Mislab		L	Power L	oss/Sur	ge	Other				
Inspection Strip in Tube					Drawing	L	Misrea										
		Marks/Ch				Drill Holes	<u> </u>	Off-set									
		Turning S				Finish	<u></u>	4	Calibration								
	Wave/Twist in Tube					Fit/Function		Out of Sequence									